

Work Order ID 71877

Wednesday, July 13, 2011 11:08:09 AM

Page 1

Item ID: D2804-2

Revision ID:

Item Name: Bracket

Start Date: 7/14/2011

Start Qty: 6.00

Required Date: 7/28/2011

Req'd Qty: 6.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan: MF

Date: 11-07-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2804

Rev C

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per File D2804-1-2_BLANK

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

0.00

0.00

ML 11 07 14 (Signature)

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per folio FA103

0.00

0.00

ML/FK 11/08/03

5 0

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

ML/FK 11/08/03

5 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71877

Wednesday, July 13, 2011 11:08:09 AM



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Item ID: D2804-2

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 7/14/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

B.A 11/08/04

5

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

5

0

0

11/08/04

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

SX 0 M 11/08/04

Quality Control

W/O:		WORK ORDER CHANGES					
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Work Order ID 71877

Wednesday, July 13, 2011 11:08:09 AM

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Item ID: D2804-2

Accept

Revision ID:

Item Name: Bracket

Start Date: 7/14/2011 Start Qty: 6.00

Required Date: 7/28/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>149</u>	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
170	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Quality Control								
	Memo	0.00							

OK 11/08/08

11-08-5
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 13, 2011 11:08:07 AM

Page 1

Work Order ID: 71877

Parent Item: D2804-2

Parent Item Name: Bracket



Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 00.11.06 New Issue EC
 IPP B 06.05.30 Blanks on wtjet EC
 IPP Rev: C As per Rev C 06-11-09 JLM
 IPP Rev: D Removed Tumbling 08-09-10 JLM Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased	No				f	39.1249		4.5			



6061-T6 Bar .500 x 10.00

12.00



11-07-19

Location

MAT004

Loc Qty

39.1249

Loc Code

111382

3

118271

36.1249

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

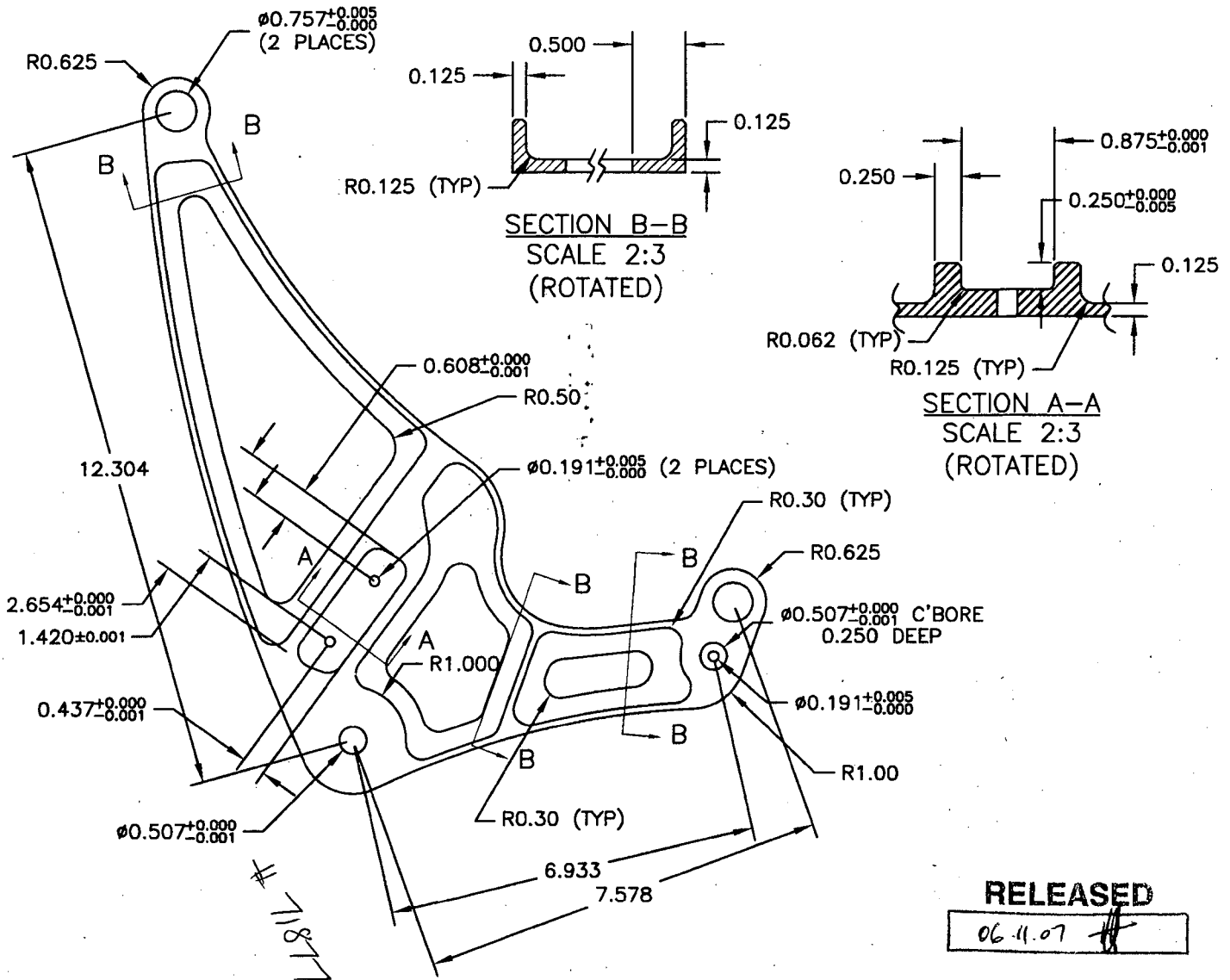
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. C
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	SHEET 1 OF 2
				D2804	
DATE	06.10.16			TITLE	SCALE
				STA 155 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	
C	06.10.16			CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

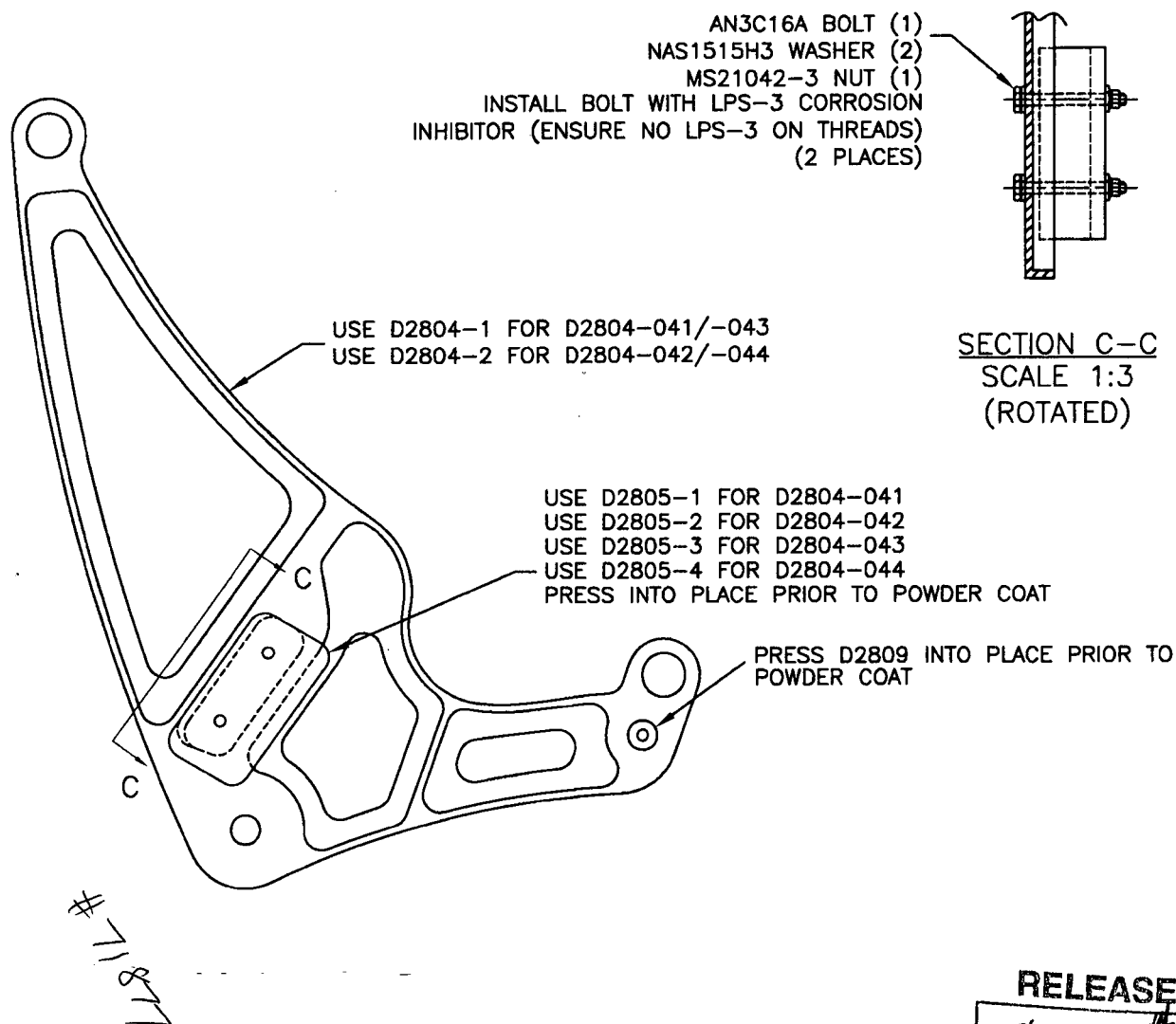
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DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D2804
				REV. C
				SHEET 2 OF 2
DATE	06.10.16	TITLE	STA 155 BRACKET	SCALE
				1:3



D2804-041/-043 BRACKET ASS'Y (SHOWN)
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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DART AEROSPACE LTD		Work Order: 71877
Description: STA 155 Bracket		Part Number: D2804-2
Inspection Dwg: D2804	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.125	✓		Vern ML7	
0.125	+/-0.010	.124	✓		"	
R0.125	+/-0.010	.125	✓		R Gauge	Ref.
0.250	+/-0.010	.251	✓		Vern ML7	
0.250	+0.000/-0.005	.248	✓		DG MLS	
0.875	+0.000/-0.001	.8749	✓		Mic MLS	
R0.062	+/-0.010	.062	✓		R Gauge	Ref.
Ø0.757	+0.005/-0.000	.7574	✓		Mic ML8	
R0.625	+/-0.010	R.625	✓		Vern ML7	
12.304	+/-0.005	12.304	✓		Vern CNC2	
Ø0.507	+0.000/-0.001	.5065	✓		Mic ML8	
0.437	+0.000/-0.001	.437	✓		Vern ML7	
0.608	+0.000/-0.001	.608	✓		"	
Ø0.191	+0.005/-0.000	.192	✓		Vern ML7	
1.420	+0.001/-0.001	1.420	✓		Vern ML7	
0.250 deep	+/-0.010	.247	✓		DG MLS	
6.933	+/-0.005	6.933	✓		Vern CNC2	
7.578	+/-0.005	7.578	✓		Vern CNC2	
0.500	+/-0.010	.501	✓		Vern ML7	

Measured by: J. A. / J. A.	Audited by: B. A.	Prototype Approval:	N/A
Date: 11/08/03	Date: 11/08/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	
C	06.11.10	Revised per drawing revision C	KJ/JLM	B

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